

POSITIVE RECALL

Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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EFFECTIVE 4/1/13 AUTH 19/7/13
RELEASED 1/10/13 DATE 26/7/2019
D3304-044

Job Sheet 197262

DAS
55
9-89

Part No: D3304-044

Job Qty: 4 pcs

Part Name: Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/3/19

Job Tracking No:

Due Date: 7/5/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: URF 19-568 DWG REV B IPP: D 04.11.26 Revised Steps 7 KJ/JLM

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier	Lead Time	Sign-off
					Setup Hrs	Run Hrs			
100	Bandsaw - 1	4 pcs		7/5/19	0.00	0.83	Bandsaw - 1		
110	Conventional Lathe - 1 - B4B	4 pcs		7/5/19	0.00	2.61	Conventional Lathe - 1 - B4B		
							Conventional Lathe - 2 - B4B		
120	QC 2	4 pcs		7/5/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

Plex 7/3/19 2:28 PM Dart.lajeunesse.marie



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Container No: S196360



Part: D3304-044

Job No: 197262

Serial No/Batch: S196360

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/08/19

130 QC 8	4 pcs	7/5/19	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
140 Small Fab - 2 - B4B	4 pcs	7/5/19	0.00 2.00	QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	19-07-09
				QC 8 - 9	
				QC 8 - 68	
150 QC 5	4 pcs	7/5/19	0.00 0.00	QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				Small Fab - 1 - B4B	SMB
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	JUL 11 2019
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
160 Large Fab - Welded Assy-2-B4B	4 pcs	7/5/19	0.00 2.25	Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	

					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					170 QC 9	4 pcs
QC 9 - 18						
QC 9 - 24						
QC 9 - 43						
QC 9 - 50	12					
QC 9 - 9						
180 QC 5	4 pcs	7/5/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	12
					QC 5 - 30	
					QC 5 - 40	
					190 Powdercoat - 3 Grey Sand - B4B	4 pcs
Powdercoat - 2 - B4B						
Powdercoat - 3 - B4B	BK 19-7-15					
Powdercoat - 4 - B4B						
START: 9:15 CUT: 3:00 FINISH: 9:45						
200 QC 3	4 pcs	7/5/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	SMB 19/1/15
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	

210 Small Fab - 3 - B4B	4 pcs	7/5/19	0.00 2.22	QC 3 - 81	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
220 QC 5	4 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
230 Packaging 3-1 - Stock - B4B	4 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

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40
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PL STY 457

240 QC 21 - SA	4 pcs	7/5/19	0.00 0.00	Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - 1- Cut blank: 22.00" as per Dwg D3304
Descriptions: 110 - 1- Cut blank: 22.00" as per Dwg D3304 2- Turn as per Dwg D3304 3- Deburr
120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - QC8- Inspect parts - second check)
140 - 1- Drill as per Dwg D3304 using drill Jig D3304-T1 2- Form as per Dwg D3304 3- Cut tube to length as per Dwg D3304 4-Check with DT8657 JIG 4- Deburr
150 - (QC5- Inspect part completeness to step on W/O)
160 - Weld bracket as per Dwg D3304 and QSI 004
170 - (QC9- Inspect visual per QSI004- Fusion Welds)
180 - (QC5- Inspect part completeness to step on W/O)
190 - (Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____
FINISH TIME: _____
200 - QC3- Inspect Part Finish)
210 - Assemble lanyard and pip pin as per Dwg D3304 Identify as D3304-044 MANUFACTURE LANDYARD AS PER D2690-10 DWG
220 - (QC5- Inspect part completeness to step on W/O)
230 - (Identify as per dwg & Stock Location: _____)
240 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.875W.065	304 Round Tube .875 X .065W	7.4168 ft (1.8542 ea)	100-Bandsaw - 1	5126574
D3304-8	Bracket	4 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	3104629
BLBS-0016	Pip Pin	4 pcs (1 ea)	210-Small Fab - 3 - B4B	137753
CBL-1240	Cable	4.1664 ft (1.0416 ea)	210-Small Fab - 3 - B4B	113791
CBL-460	Loop Sleeve	8 Ea (2 ea)	210-Small Fab - 3 - B4B	187877

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M304TR0.875W.065	7	28	0
160-Large Fab - Welded Assy-2- B4B	D3304-8	4	16	0
210-Small Fab - 3 - B4B	BLBS-0016	4	16	0
	CBL-1240	4	54	0
	CBL-460	8	1,037	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

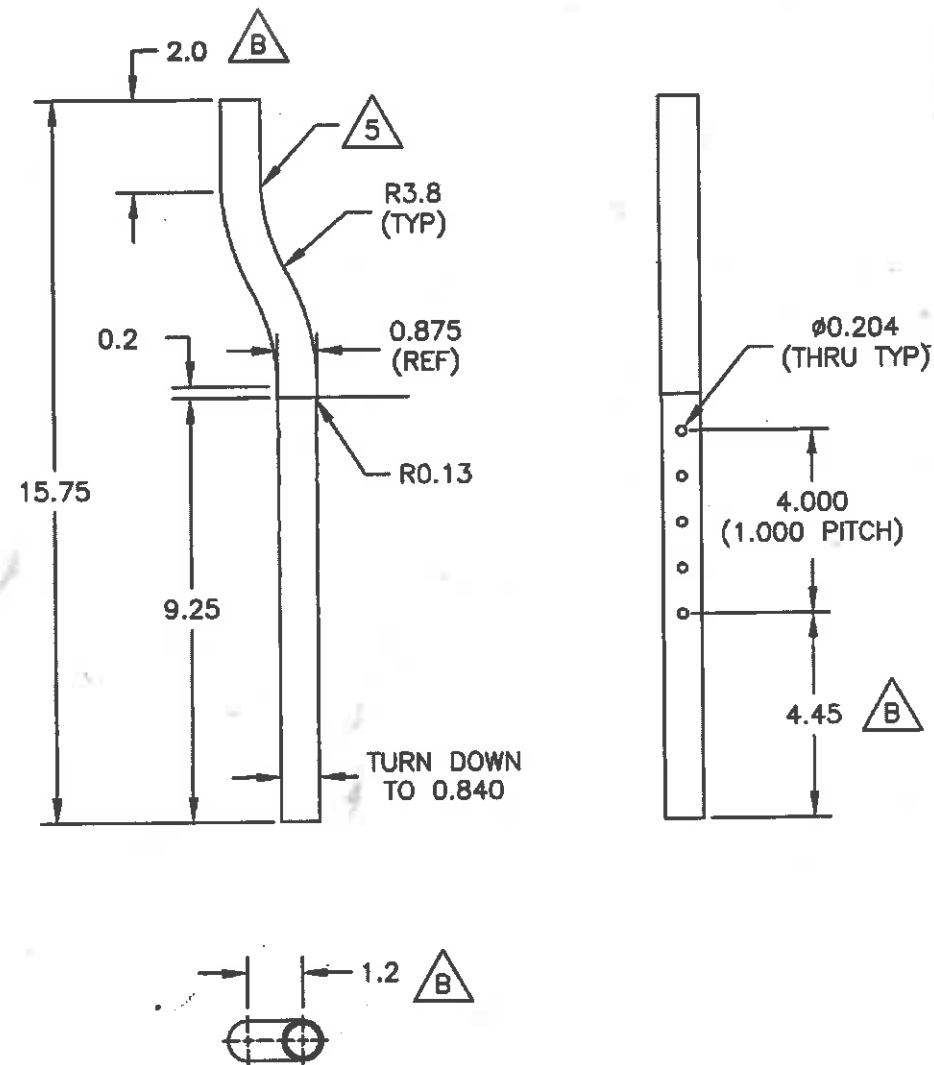
Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				Completed By Lead hand / Supervisor QC / QA Coordinator	

UNDER REVIEW

URF 19-568 19.02.08 (SAD)

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:4



D3304-3 TUBE

D3304-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

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